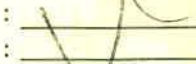
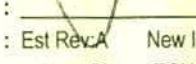


Date: Tuesday, 09/10/2007 2:55:09 PM
User: Linda Lacelle

Process Sheet

Split #2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 35029 -2		
Estimate Number	: 12578	Part Number	: D3560041
P.O. Number	: N/A	Drawing Number	: D3560 REV C
This Issue	: 09/10/2007 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: N/A	Material	: N/A
Previous Run	: 35029	Due Date	: 19/10/2007
Written By	: 	Qty:	10 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev: A New Issue 07.05.24 EC est rev B ECN 987 07.10.09 EC verified by: DD		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 14.6475 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: W10575C

J.L 07/10/24

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks 16.750" long

J.L 07/10/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: A/A & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

J.L 07.10.25

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07.10.25

Date: Tuesday, 09/10/2007 2:55:09 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35029

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL

07/10/28

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
PLATE 3 34478 = 2

JK 07.10.29 (2)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

770 ->

1-Weld assembly as per dwg D3560

JK

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (60)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

JK

JK

JK

JK

JK

JK

JK

JK

JK 07.10.29 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JK 07/10/28 (X204)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JD 07.10.29 (2)

Date	Step	split w/o for Qty 2 on this w/o (-2) left 8 qty on (-1)	Zuhair Ahmad 07/10/27 07/10/27
01.10.29	7.0		

Pat Swars

Date: Tuesday, 09/10/2007 2:55:09 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35029

Part Number: D3560041

Job Number:



Seq. #: Machine Or Operation: Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 07/11/01 (2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-11-01 (2)

12.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

batch:

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

done on D3562.041

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O W

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

WA

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2) Done 07/11/19

Job Completion



W/O Still B

Date: Friday, 10/5/2007 10:58:37 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 35029	
Estimate Number : 12578	
P.O. Number :	Part Number : D3560041
This Issue : 10/5/2007 S.O. No. :	Drawing Number : D3560 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : <i>BC</i>
Previous Run : 34964	Material :
Written By :	Due Date : 10/19/2007 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est Rev: A New Issue 07.05.24 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
-----	--------------------	-------------------------



Comment: Qty.: 1.4648 f(s)/Unit Total: 14.6475 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: _____

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks 16.750" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: _____ & Dwg D3560 Rev: _____

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Date: Friday, 10/5/2007 10:58:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35029

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
PLATE

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DART AEROSPACE LTD		Work Order:	35029
Description: Arm		Part Number:	D3560-1
Inspection Dwg: D3560	Rev: B/C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

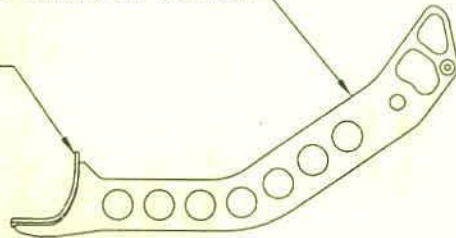
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Ø0.196	+0.005/-0.001	.196	✓			
Ø1.000	+0.010/-0.001	1.000	✓			
0.500	+/-0.010	.498	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.274	✓			
0.188	+/-0.010	.188	✓			
2.000	+/-0.010	2.000	✓			
1.700	+/-0.010	1.700	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.385 x 100°	✓			
0.250 Deep	+/-0.010	.250	✓			

Measured by: <i>BC</i>	Audited by: <i>JML</i>	Prototype Approval:	N/A
Date: <i>07/10/27</i>	Date: <i>07/10/27</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM <i>JA</i>	<i>BE</i>

D3560-1 ARM (-041, SHOWN)
OR D3560-2 ARM (-042, OPPOSITE)

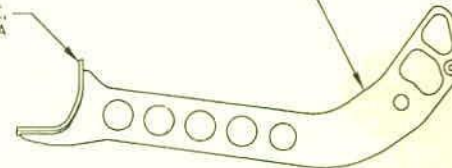
D3592-1 PLATE,
SEE DETAIL A



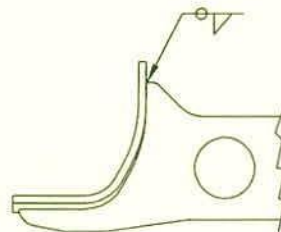
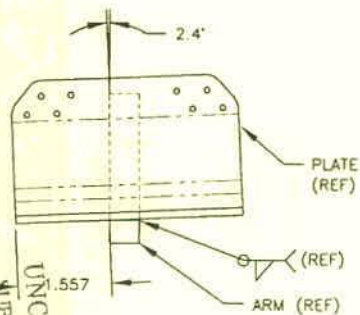
D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

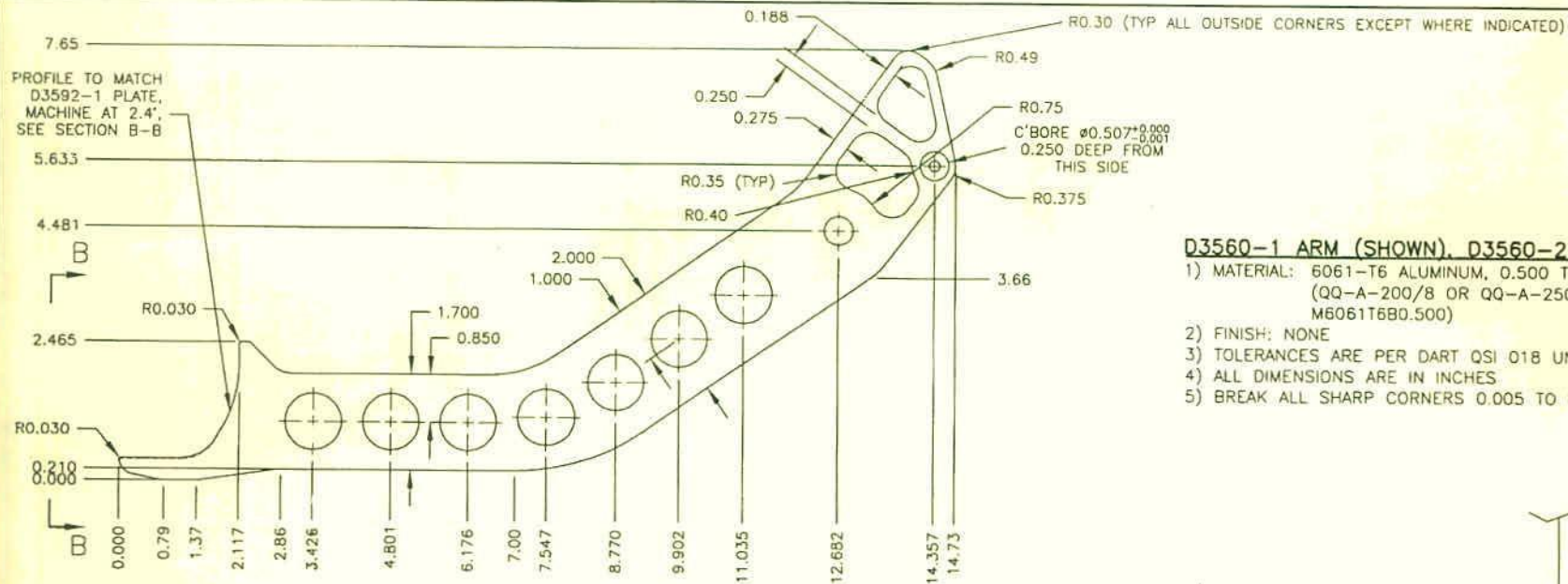
RELEASED
07.06.19

NO. 35007
WORK ORDER
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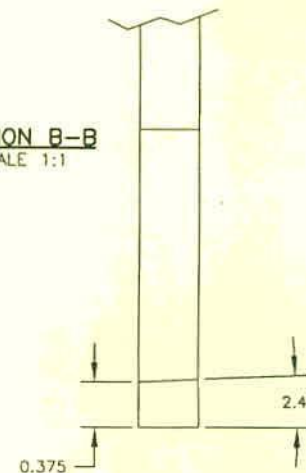
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	07.06.19	TITLE ARM WELDMENT
		REV. C SHEET 1 OF 3 SCALE 1:4



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

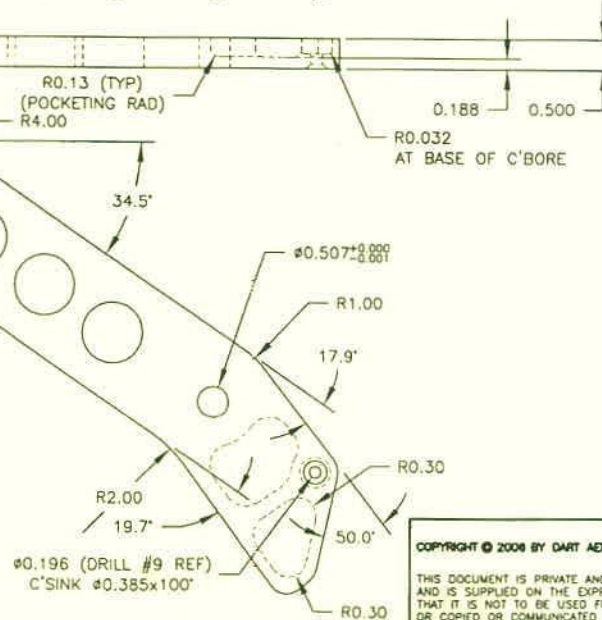
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B
SCALE 1:1



RELEASED
07.06.19

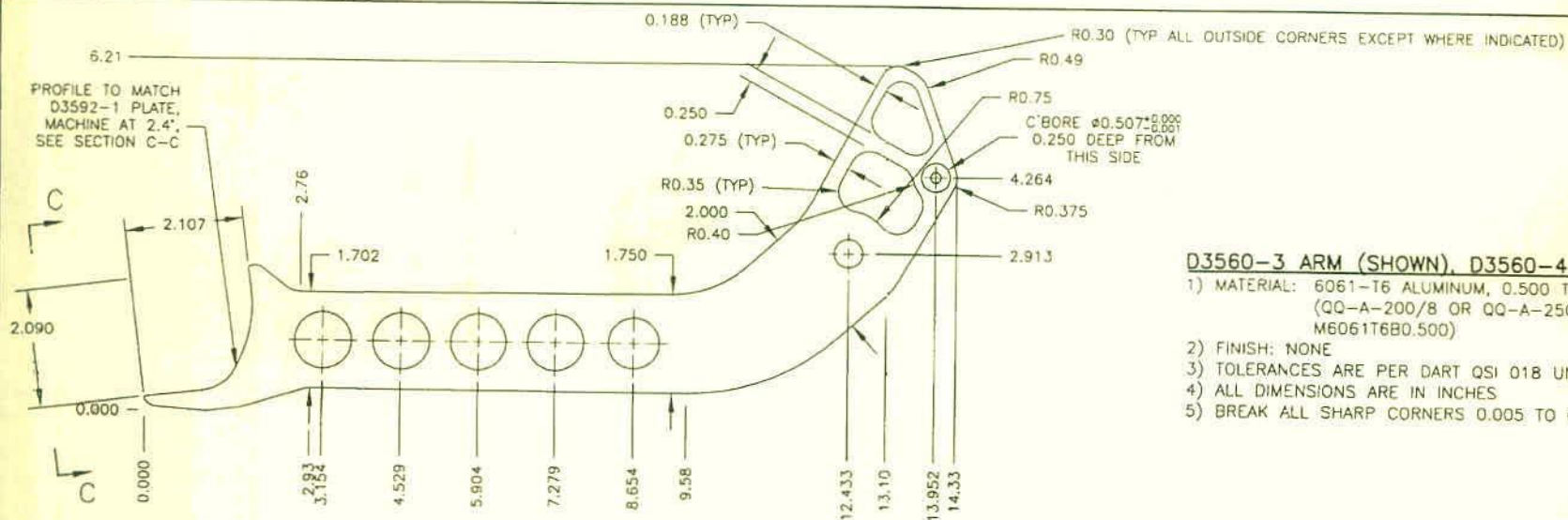
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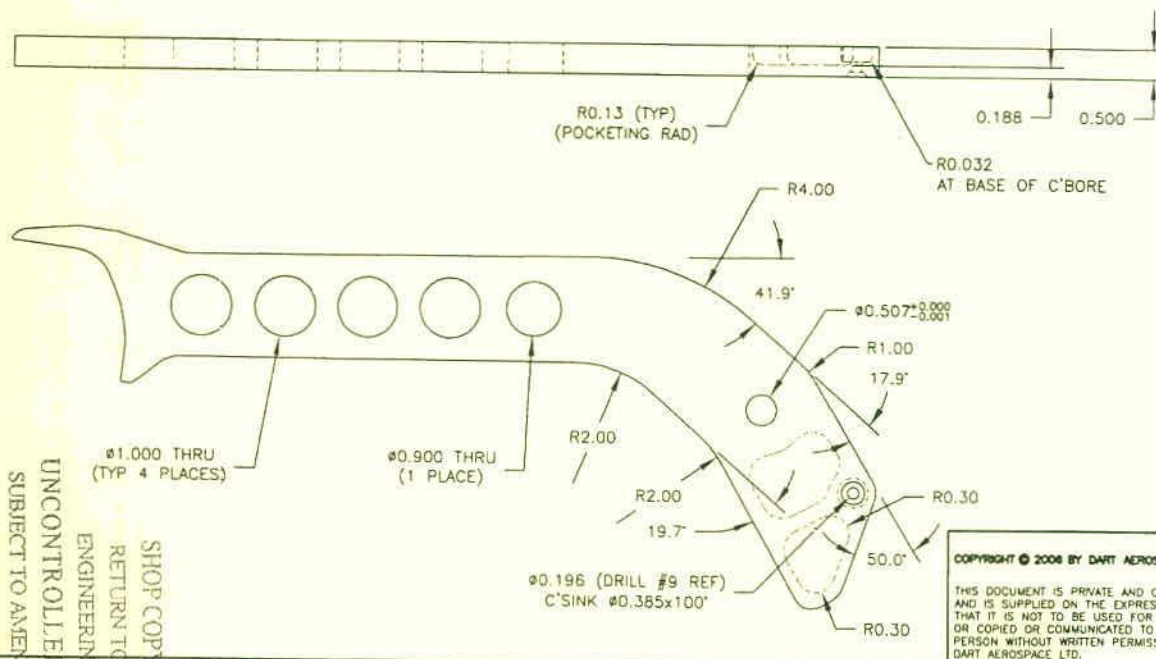
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CHECKED	dt	APPROVED	dt	DRAWING NO. D3560	REV. C
DATE	07.06.19	TITLE	ARM WELDMENT	SHEET 2 OF 3	SCALE
					1:2

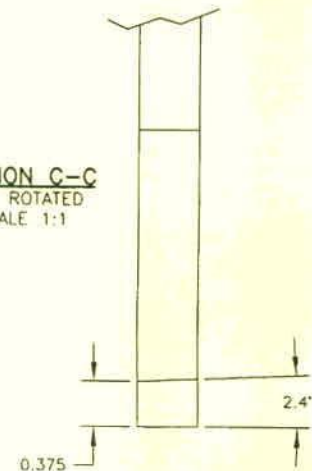


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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CHECKED	th	APPROVED	th	DRAWING NO.	REV. C
DATE	07.06.19	TITLE	ARM WELDMENT	D3560	SHEET 3 OF 3
		SCALE	1:2		

